

Date: Tuesday, 21/10/2008 2:45:31 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 42770		
Estimate Number	: 10313		
P.O. Number	:	Part Number	: D26483
This Issue	: 21/10/2008 S.O. No. :	Drawing Number	: D2648 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 42631	Material	:
Written By	:	Due Date	: 11/11/2008 Qty: 40 Um: Each
Checked & Approved By	: <u>JUL 08.10.21</u>		
Comment	: Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF Est Rev:F Now on Waterjet 06-08-14 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025 sheet 16GA
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Comment: Qty.: 0.0788 sf(s)/Unit Total: 3.1500 sf(s)
 1010/1025/A21/6aA SHEET
 (M1010S16GA)
 Batch: 105706 B8-10-23

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2648
 *****CUT WITH FILE D2648-1*****
 Dwg Rev: D
 Prog Rev: D B8-10-23

(48)

2-Deburr if necessary B8-10-23

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B8-10-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

508/10/24cauter

(x48)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Doc at Step 02.2

Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

2/4508/10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PAR #: Fault Category: NCR: Yes No DQA: Date:
 QA: N/C Closed: Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

- 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.
- 2-Identify as D2648-3

SB 08/10/21

48

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- Qty Description Batch
- A/R560Hardcoat M109560
- 1-Weld as per Dwg D2648 using Jig DT 8210
- 2-Remove any weld that penetrated through Wearpad if necessary

EL 8-10-28

48

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 28/10/28 (48)

counted

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/28 (48)

10.0

POWDER COATING

POWDER COATING



M 10 6 442



(48X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:10
320 OF
9:40

M-J 08/10/31

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-31

(48)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

F P-17

M-J 08/10/31

(48X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 42770

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

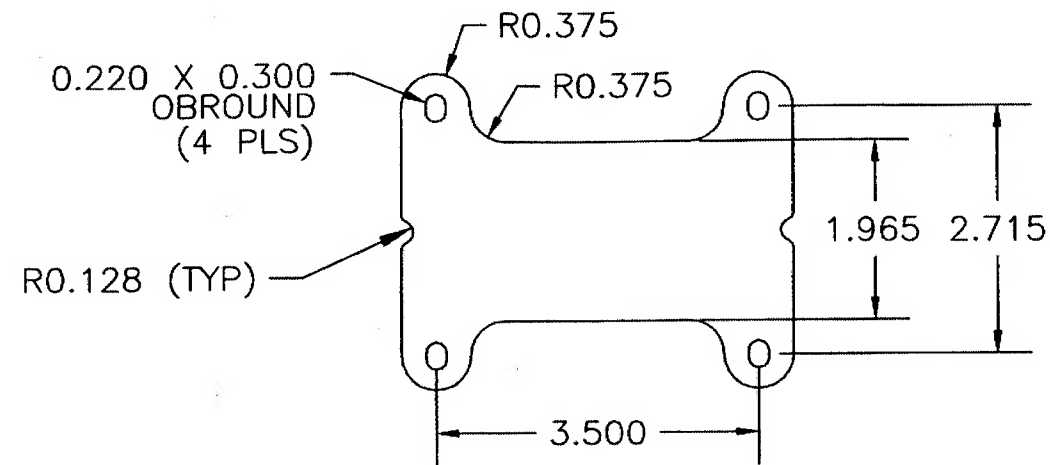
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

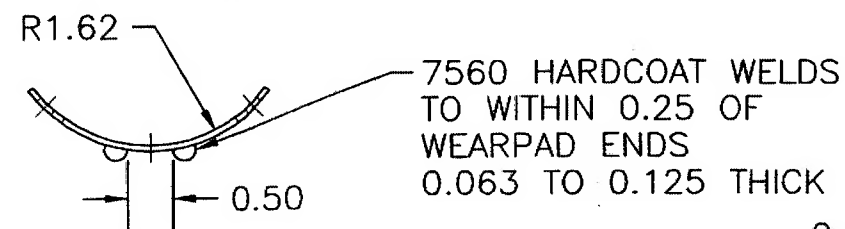
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

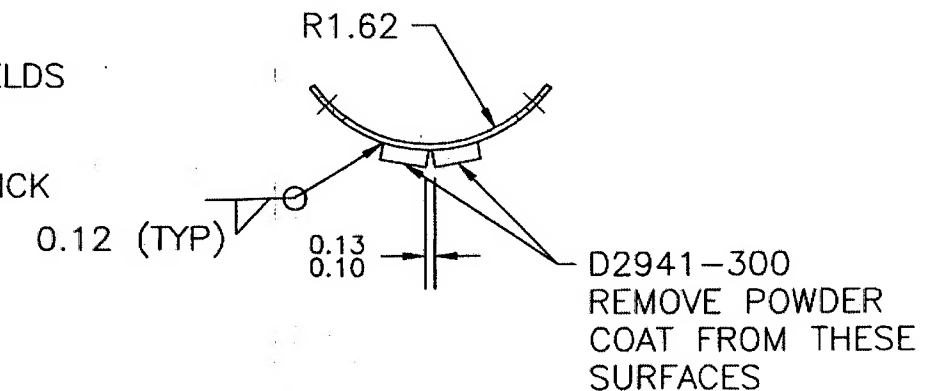
D2648-1 FLAT PATTERN



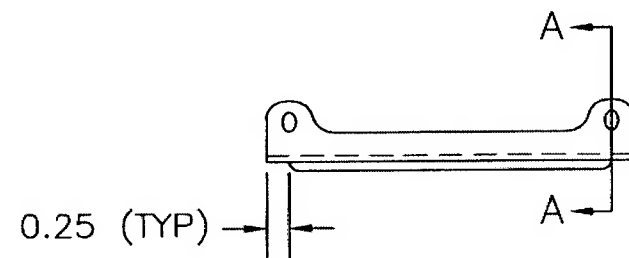
SECTION A-A



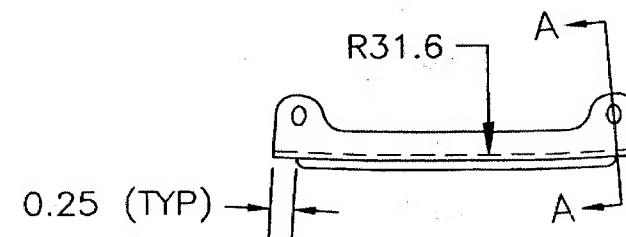
SECTION B-B



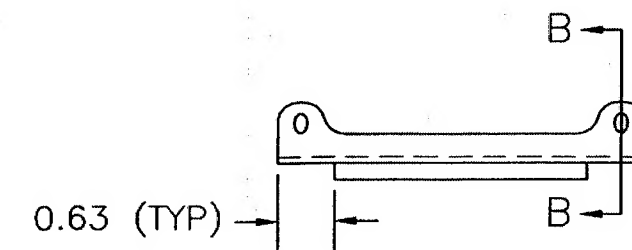
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42270

RELEASED
99.12.20 DS



BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2648
DATE	99.11.17	TITLE WEARPAD
		REV. D SHEET 1 OF 1 SCALE 1:2